

Wednesday, 22/10/2008 4:08:45 PM

Julie Dawson

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 42875

: 13302 **Estimate Number**

P.O. Number

Prsht Rev.

First Issue

Written By

Previous Run

: 22/10/2008 This Issue

: NC

: 11 : 40869 Type

S.O. No. :

: MACHINED PARTS

Part Number

Drawing Name

: D37751

Drawing Number

: D3775 REVB : N/A

: GUARD

Project Number

; B **Drawing Revision**

Material

Due Date : 07/11/2008 Qty:



Each

Checked & Approved By

Comment

: Est Rev:A New Issue 08-05-05 JLM Verified By:EC

Est Rev:B 08-07-18 revB as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

MDELRINR1500



Inventory



Comment: Qty.:

0.2468 f(s)/Unit

Total:

2.4675 f(s)

1.50" Black Delrin Bar

Batch:

M108460

DOOSAN LATHE



2.0

1.0

DOOSAN LA

Comment: DOOSAN LATHE

& Dwg D3775Rev: <u>1</u> 1- Turn as per Folio FA742 Rev:

2-Deburr per dwg D3775

3.0 QC2



4.0

5.0



PARTS AS THEY COME OFF MACHINE Comment: INSPECT

SECOND CHECK



QC8



Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1







Comment: PACKAGING RESOURCE #1







Dart Ae	rospace	Ltd						
W/O:			W	ORK ORDER CHANGE	ES			
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			18 S.M					
		•						
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:	Date: _	
					QA: N	/C Closed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R) .		
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A Initial Chief Eng		Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCK)								
DATE		Description of NC Corrective Action Section B				Verification	A	A		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

Date: User: Wednesday, 22/10/2008 4:08:45 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUARD

Job Number: 42875

Part Number: D37751

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/274

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



4 08,11,27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
٠												
Part No	:	PAR #: Fault Category:	NCR: Y	es No DO	QA:	Date: _						
			QA	A: N/C Close	ed:	Date:						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42875				
Description: Guard	Part Number: D3775-1				
Inspection Dwg: D3775 Rev: B	Page 1 of 1				

FIRST ARTICLE INSPECTION CHECKLIST								
X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments	
2.82	+/-0.030	2.824						
0.100	+/-0.010	102						
0.73	+/-0.030	7325						
0.050 x 45°	+/-0.010 x 0.5°	050x45°						
R0.025	+/-0.010	R-032	/					
Ø0.323	+0.006/-0.001	Ø. 323	/					
Ø0.600	+/-0.010	0,603						
Ø1.500	+/-0.010	\$1.505						
			,					
			_					
					_			
				_				
Measured by:		Audited by:			Prototype Approval:		N/A	
Date:	58111120	Date:	08/11/	20		Date:	N/A	
RevDateChangeRevised by ApproximationApproximationA08.09.04New IssueKJ/DD						Approved		

-0.100 С 0.73 -0.050 X 45° CHAMFER R0.025 Ø0.323 THRU Ø1.500 R0.025 Ø0.600 REF 2 PL RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT **D3775-1 GUARD** B RE-DESIGN -1 FOR LONGER PROFILE, ELIMINATE -3 HS 08.06.10 NEW ISSUE HS 08.06.04 REV. DESCRIPTION BY DATE DESIGN HS DART AEROSPACE LTD NOTES:
1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL ROUND BAR (REF. DART SPEC. M-DELRIN-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs DRAWN HS HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3775 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE GUARD DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD
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